

Date: Thursday, 18/12/2008 12:51:52 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 44177	
Estimate Number : 13066	
P.O. Number :	Part Number : D36811
This Issue : 18/12/2008 S.O. No. :	Drawing Number : D3681 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 18/12/2008 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 41248	Material :
Written By :	Due Date : 23/12/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JD 08.12.19</u>	
Comment : Est Rev A new issue 07-10-30 DD verified by: Est Rev:B Ecn 1056 Rev A dwg DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T03125W058	ALUM TUBE .3125 x .058w
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Comment: Qty.: 0.3570 f(s)/Unit Total: 14.2800 f(s)

Material:

(M6061T6T0.313W.058)

Batch: 11109240

mf 08/12/20

(40)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA711& DWG D3681

FOLIO REV: AADWG REV: A

2-DEBURR AS REQUIRED

mf 08/12/20

(40)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 08/12/20

(40)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mf 08.12.22

40

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Barkley

SS 08/12/22 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 44177

Part Number: D36811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/22 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 08.12.22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

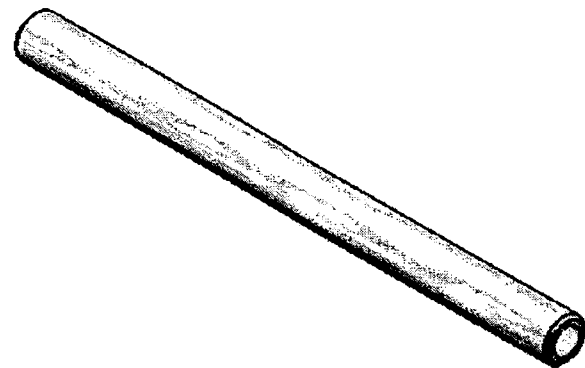
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

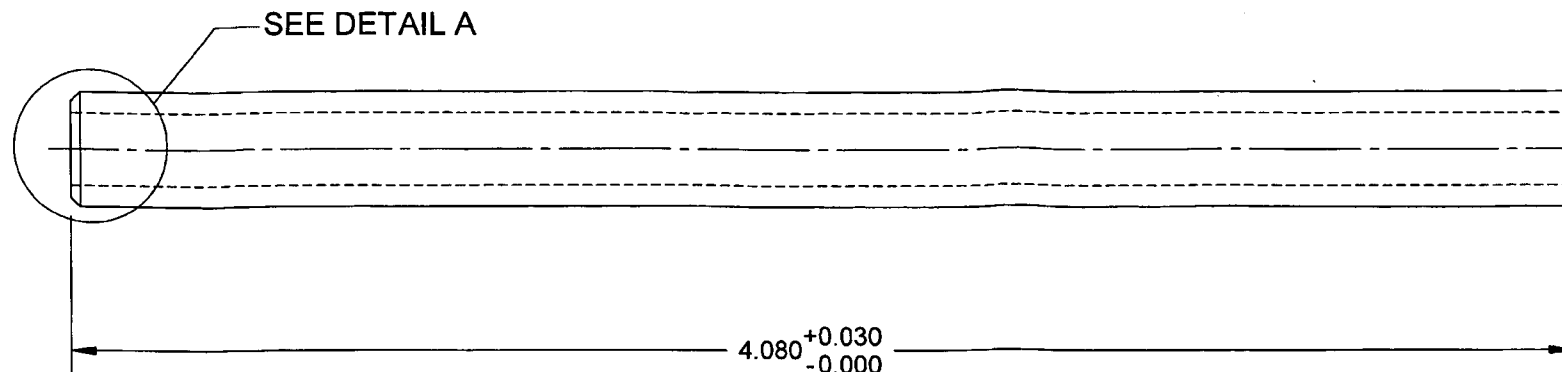
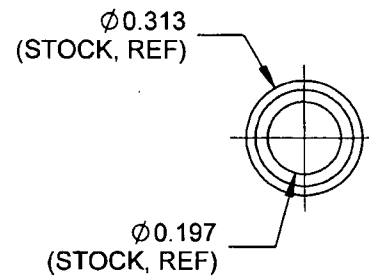
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

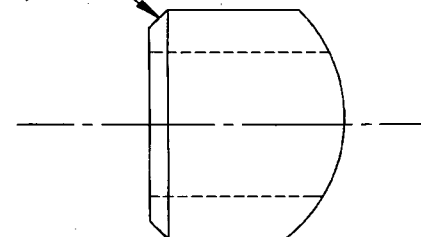




**D3681-1 SPACER**



0.025 X 45°  
CHAMFER  
(TYP)



**DETAIL A**  
(SCALE 4 : 1)

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082  
OR QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

**RELEASED**  
07-11-09

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 44177

A	NEW ISSUE	DC	07.11.08
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	MS	DRAWING NO.	REV. A
MFG. APPR.	ED	D3681	SHEET 1 OF 1
APPROVED	W	TITLE	SCALE
DE APPR.	W	SPACER	2:1
DATE	07.11.08	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	